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(54) **FLOW CONTROL VALVE WITH EDDY CURRENT DAMPENING**

(57) A valve is provided having an inlet to receive a flowable particulate media and an outlet to dispense the media. The valve has an inlet portion with a funnel and repelling magnets (48). A shuttle sleeve (50) extends from the inlet portion to allow a shuttle (70) to slide along a central axis between an opened and a closed position. The shuttle (70) has shuttle magnets (72) that are oriented to have poles that face the repelling magnets (48) to create a biasing force that biases the shuttle (70) towards the closed position. When the shuttle (70) moves, the shuttle magnets (72) create eddy currents in a tube. The closed position is defined by a sealing edge of the shuttle (70) contacting a sealing surface on a flow director. A capacitive sensor surrounds the flow director to measure the amount of media that is dispensed by the valve.

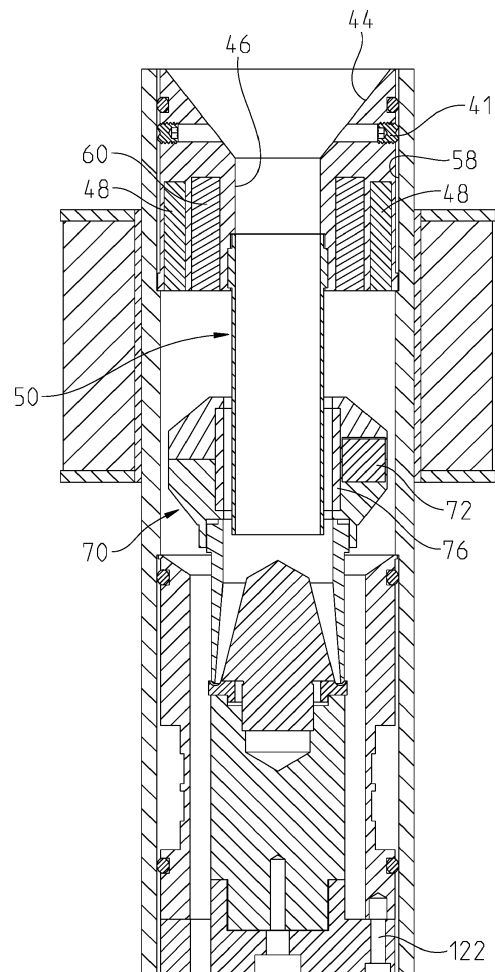


Fig. 2

Description

BACKGROUND OF THE INVENTION

[0001] This present disclosure relates to flow control valves that control the flow of particulate, such as is used in media blasting, shot peening, or other systems where the user desires to control the flow of different types of flowable particulate and sense the amount passing through the valve. Existing flowable particulate valves in the art suffer from complexity, manufacturability, and functionality issues. Most valves use a fixed orifice and a movable pintle that retracts to allow media to flow. The pintle is spring-loaded to bias it towards the closed position, creating issues for assembly and maintenance. The spring can wear, break, or become damaged, creating functionality issues. When actuated, the pintle can bounce, creating control problems. Another problem is having closed loop control of the valve by knowing exactly the amount of media that is being dispensed. Other designs use a deflected beam as a means to measure, while others use optical or other sensing technology. An improved valve with media sensing is needed.

SUMMARY OF THE INVENTION

[0002] The present disclosure describes a valve designed to regulate the flow of a particulate media. The valve has an inlet portion that funnels the particulate media down through the center of the valve. The inlet portion has repelling magnets and a shield. The shield reduces the magnetic field from the magnet that passes through the center of the valve. The inlet portion has a shuttle sleeve that carries the particulate media on the inside. Surrounding the outside of the shuttle sleeve is a movable shuttle. The shuttle has shuttle magnets and a magnetic shield that reduces the magnetic field from the magnets that passes through the center of the valve. The shuttle has a movable orifice attached to it that contacts a flow director. The flow director is located in the outlet portion and channels the media past a flow sensor to detect the amount of particulate being dispensed. A portion of the valve is made from a metal, such as brass or copper, that interacts with the shuttle magnets to generate eddy currents when the shuttle is in motion. The eddy currents act to dampen the movement of the shuttle.

BRIEF DESCRIPTION OF THE DRAWINGS

[0003]

FIG. 1 is an isometric view of the valve;

FIG. 2 is a section view 2-2 of the valve in FIG. 1;

FIG. 3 is a section view 3-3 of the valve in FIG. 1 showing the shuttle in the closed position;

FIG. 4 is a section view of the valve in FIG. 3 showing the shuttle in the open position;

FIG. 5a is a section view 2-2 of the valve in the closed position and particulate media not being dispensed;

FIG. 5b is a section view 2-2 of the valve in the open position and particulate media being dispensed so that the flow path may be seen;

FIG. 6 is a section view of the valve as disassembled;

FIG. 7 is an isometric section view of the valve in FIG. 6;

FIG. 8 is an exploded isometric view of the sensor and tube assembly; and

FIG. 9 is a graphical representation of shuttle position over time with and without eddy current damping.

DESCRIPTION OF THE PREFERRED EMBODIMENT

[0004] An electrically operated valve 10 is shown in FIGS. 1-8 with an inlet 12 and an outlet 14. The valve 10 is designed to regulate the flow of particulate media that is not ferro-magnetic. The particulate media is flowable, commonly a blasting media such as glass, plastic, aluminum oxide, or other particulate. In other words, particulate media made from steel or alloys of Iron are not commonly used with the valve 10. The particulate media is loaded into the inlet 12, commonly from a hopper or other storage vessel (not shown). The valve 10 is operable between an opened state and a closed state. The opened state allows particulate media to flow from the inlet 12 to the outlet 14, while the closed state blocks the particulate media from flowing. The valve 10 can operate in positions between the open and closed positions in order to regulate the flow of particulate media.

[0005] The valve 10 has a tube 20 that is shown as a hollow cylindrical tube with a consistent wall thickness, but other structures are contemplated, such as a square, rectangular, or other elongate hollow component that allows a flow path. The inlet 12 is located near a top edge 22 and the outlet 14 is located near a bottom edge 24. The tube 20 may be threaded at its ends or have a feature to allow it to attach to other containers, tubes, or devices. The valve 10 has a central axis 16 that is located at the center of the tube 20. The tube 20 has an inside surface 26 where other components contact or seal against. The tube 20 in the embodiment described herein is formed from copper or a copper alloy, such as brass or bronze. The tube 20 may also be made from aluminum or other material that is electrically conductive or responds to a changing magnetic field.

[0006] A coil 32 surrounds the tube 20 that is also fixed with respect to the tube 20. The coil 32 has windings 34

that generate a magnetic field when energized. The valve 10 may include a housing (not shown) that surrounds a portion of the tube 20 and includes controls, wiring, and circuit boards.

[0007] A funnel 40 is located adjacent the top edge 22 and is shown as centered about the central axis 16. A seal 42 seals the funnel 40 to the inside surface 26 of the tube 20. The funnel 40 has a wide open mouth with an inside surface 44 that narrows down to a cylindrical surface 46. The inside surface 44 is conical in nature but the device is not limited to that shape. It is contemplated that the inside surface 44 of the funnel 40 is straight and any funnel or conical feature is externally located above the valve 10. The funnel 40 may also be considered as an inlet portion. The funnel 40 is axially located in the tube 20 by a step surface 45 and includes set screws 41 that impinge against the tube 20 and prevent movement of the funnel 40 with respect to the tube 20. The funnel 40 includes repelling magnets 48 that are equally spaced around the cylindrical surface 46. The repelling magnets 48 are pressed into place or otherwise secured with adhesive or fasteners that prevents the magnets 48 from falling out or becoming loose. The funnel 40 is made from a non-magnetic material, such as plastic, aluminum, ceramic, or other material that does not short out or conduct the magnetic field from the repelling magnets 48. The inside surface 44 and cylindrical surface 46 cooperate to direct particulate to the inside of a shuttle sleeve 50. The shuttle sleeve 50 is a cylindrical tubular component, made from a non-magnetic material such as plastic or aluminum, with an inside surface 52 and outside surface 54. The shuttle sleeve 50 is secured to the funnel 40 through a press fit, threading, or other attachment method that affixes the two components. The shuttle sleeve 50 is centered about the central axis 16 and has a terminal edge 56 that is opposite the open mouth. To maintain the coaxial position of shuttle sleeve 50 to the central axis 16, a skirt surface 58 that is closely matched to the inside surface 26 of the tube 20 extends down from the open mouth to the top of the shuttle sleeve 50. Adjacent the repelling magnets 48 is a funnel shield 60 that conducts magnetic field from the repelling magnets 48 to keep the magnetic field away from the inside flow path of the funnel 40. Because ferrous or other particulates with magnetic attraction may pass through the flow path, a strong enough magnetic field in the flow path would create an undesirable buildup of these particles that would impede flow of the particulate media. The funnel shield 60 shunts the field to the point that ferrous or magnetic particles do not accumulate.

[0008] A shuttle 70 is located around the shuttle sleeve 50 and also centered about the central axis 16. The shuttle 70 is hollow and slidable along the outside surface 54 of the shuttle sleeve 50 between an open position (shown in FIG. 4) and a closed position (shown in FIG. 3). The shuttle 70 has shuttle magnets 72 that are contained in a shuttle body 74. The shuttle body 74 is made from a non-ferromagnetic material, such as plastic, aluminum,

ceramic, or other material that does not short out or conduct the magnetic field of the shuttle magnets 72, and includes a shuttle magnet shield 76 that is located adjacent the shuttle magnets 72 and closer to the central axis 16. The shuttle magnet shield 76 shunts the magnetic field generated by the shuttle magnets 72 that could attract ferrous particles or other particles. The particles may be attracted to a magnetic field and build up on the shuttle sleeve 50 or the shuttle 70, or get stuck between the shuttle body 74 and shuttle sleeve 50. Extending from the lower portion of the shuttle body 74 and affixed thereto is a movable orifice 78. The movable orifice 78 is a tubular component with a terminal sealing edge 80, shown in FIG. 4. In the embodiment described herein, the movable orifice 78 is made from metal (such as aluminum), but other materials are contemplated. The movable orifice 78 includes a tapered surface 82 located on the inside that extends from the inside surface 84. The media flows from the shuttle sleeve 50 and into the inside of the movable orifice 78. The tapered surface 82 may include other features designed to modify the flow properties of the particulate media, such as channels, different angles, or additional surfaces. To remove the shuttle 70 for maintenance, cleaning, or exchange the movable orifice 78, the user removes the funnel 40 and shuttle sleeve 50 and lifts the shuttle 70 out through the top of the tube 20.

[0009] A fixed flow director 90 is affixed to the tube 20 near the bottom edge 24 and is also centered about the central axis 16. The flow director 90 has a removable cone portion 92 with a replaceable seal 93 having a sealing surface 94. The terminal edge 56 of the shuttle sleeve 50 is spaced above the sealing surface 94 and the two are a fixed distance apart. In the embodiment described herein, the replaceable seal 93 is made from steel, but other materials are contemplated. The sealing surface 94 is groove-shaped to receive and locate the terminal sealing edge 80 on the shuttle 70. It is held between the cone portion 92 and the flow directing portion 100, which may be press fit or threaded. The cone portion 92, as shown, is tapered with a top and conical surface 96, 98. The cone portion 92 may be parabolic, curved, or straight, depending on the properties of the particulate media that may be used. The flow directing portion 100 has an outer diameter surface 102. A mounting base 104 locates the fixed flow director 90 to be aligned with the central axis 16 and allows flow through it via arcuate apertures 106. The cone portion 92 and sealing surface 94 is designed to mate with the movable orifice 78 and the terminal sealing edge 80 to open or close a flow path between the funnel 40 and flow directing portion 100. The fixed flow director 90 is separable from the base 104 to allow different cone portion 92 and flow directing portions 100 to be exchanged for different desired flow properties of the particulate media. The flow director 90 may have a different shape than the flow director 90 shown in FIG. 3. The purpose of the flow director 90 is to direct media outwardly from a central region of the tube 20 and toward the inside surface 26 of the tube 20. For instance, it is

not necessary that the flow director 90 have a cone portion 92. The flow directing portion 100 of the flow director 90 will prevent media from being located in the central region of tube 20, which corresponds to areas of the tube 26 that adjacent to the central axis 16 of the tube 26.

[0010] The absence of an applied magnetic field from the coil 32, gravity, and the repelling magnets 48 result in the shuttle 70 resting in the closed position where it contacts the fixed flow director 90. Additionally, if it is desired that shuttle 70 be closed quickly, the polarity on the coil 32 may be reversed so that the coil 32 drives the shuttle 70 downward. In the closed position, shown in FIG. 5A, the movable orifice 78 contacts and seals against the sealing surface 94 and particulate media does not flow. As an electrical current is applied to the coil 32, the shuttle 70 begins to move away from the fixed flow director 90, such as shown in FIG. 5B. Due to the shape of the cone portion 92 and tapered surface 82, the distance the shuttle 70 moves away from the cone portion 92 creates a variable gap for the particulate media to pass through. Increasing the amount of energy applied to the coil 32 increases the amount that the shuttle 70 moves away from the closed position.

[0011] A flow sensor 110 surrounds the fixed flow director 90 that detects the amount of particulate media that is passing between the outer diameter surface 102 and flow sensor 110. The flow sensor 110 is shown as located and attached to a flow sensor body 112. The flow sensor body 112 is located between the mounting base 104 and a step 107 in the tube 20. The flow sensor body 112 is sealed to the tube 20 with seals 108, 109. The sensor 110 is capacitive and includes sensor rings 114, 116 that sense movement of the particulate media adjacent the sensor rings 114, 116. The sensor rings 114, 116 are near the inside surface 26 of the tube 20. Wires connect the sensor rings 114, 116 to an external circuit through a channel 118 in the sensor body 112 and out through the wire egress 120. The external circuit is commonly located inside the housing (not shown) and can be used by the valve 10 for closed loop control of the shuttle 70. The flow sensor 110 and sensor body 112 are secured to the tube 20 using fasteners, adhesive, or other method. The mounting base 104 is secured through fasteners 122. Removing the fasteners 122 allows the mounting base 104, flow directing portion 100, cone portion 92, and replaceable seal 93 to be removed for maintenance, cleaning, or component exchange for a different media. The flow sensor 110 is shown as using sensor rings 114, 116 that are adjacent the flow path for the particulate media, but it is contemplated that other sensor designs are used. To obtain a reliable signal for detecting media, within the flow sensor 110, it is desirable to have the media near the sensor rings 114, 116. For this reason, the flow director 90 directs media relatively near the sensor rings and away from the central axis 16 of the tube 20, where the media would be relatively far from the sensor rings. If sensor configurations not using capacitive elements such as rings 114, 116 are employed, it is de-

sirable for the media to be located near the capacitive elements and the flow diverter 90 serves that purpose. As an alternative embodiment for a sensor could be the use of one sensor ring is located in the flow sensor body 112, and the other ring is located in the flow directing portion 100. In such a case, it is still desirable that media be predictably directed by the flow director 90 to consistently locate the flow path of media between and near capacitive elements. It is further contemplated that the flow directing portion 100 may be made from a material that conducts and connects to the external circuit 118 to form part of the sensor 110.

[0012] The repelling magnets 48 in the funnel 40 have a north-south orientation that puts the magnetic field as it exits the magnet parallel to the central axis 16. Some of the field is conducted through the funnel shield 60. The shuttle magnets 72 are aligned in a similar fashion such that the magnetic field as it exits the magnet is parallel to the central axis 16, with some of the field conducted through the shuttle magnet shield 76. The shuttle magnets 72 and repelling magnets 48 have identical facing poles and generate an increasing repelling force as they are brought closer to each other. For example, if the shuttle magnets 72 have a north pole that faces the repelling magnets 48, the repelling magnets would be oriented to have a north pole that faces the shuttle magnets 72. The repelling force generated by the magnets 48, 72 acts like a spring that biases the shuttle 70 away from the funnel 40. Because of the biased force from the magnets 48, 72, no spring is required. Ordinarily, a valve would require a spring to ensure the shuttle returns to the closed position when the electric current is removed.

[0013] When an electric current is passed through the windings 34 in the coil 32, a magnetic field is generated that draws the shuttle 70 towards the funnel 40, which separates the terminal sealing edge 80 from the sealing surface 94. The greater the electrical current that is passed through the coil 32, the greater the magnetic force is that is applied to the shuttle 70, which causes it to move closer to the funnel 40. As the shuttle 70 gets closer to the funnel 40, the repelling magnets 48 begin to counteract the magnetic force from the coil 32. When a magnetic field is generated by the coil 32, the response from the shuttle 70 is non-linear due to the exponential increase of magnetic field over decreased distance. This means that when the shuttle 70 moves closer to the desired position, the amount of magnetic field needed to position the shuttle 70 would be less than what was generated to move it from its closed and resting position, resulting in the shuttle 70 moving past the desired position. By adding in the repelling magnets 48, magnetic force repelling the shuttle 70 counteracts the natural increase of force as the shuttle moves closer to the coil 32. With this, the shuttle position is more proportional to the amount of electrical current provided to the coil 32.

[0014] As previously mentioned, the tube 20 may be made from copper, aluminum, or a copper alloy, and the shuttle 70 has an array of shuttle magnets 72. Because

the shuttle magnets 72 are in close proximity to the tube 20, any movement of the shuttle 70 creates eddy currents in the tube 20. Eddy currents are created when a magnet is moved with respect to a conductive metal, such as brass, copper, or aluminum. The tube 20 in the embodiment herein is described as brass but other materials are contemplated. The valve 10 takes advantage of the eddy currents and uses them to act as a dampening force on the shuttle 70. Without eddy currents, when the coil is first energized, the shuttle 70 would react in an underdamped fashion 73, where it would first overshoot its desired position 71 and then oscillate until it settles down to its desired position 71. In other words, the shuttle 70 would bounce back and forth before arriving at its desired position 71, represented in FIG. 9. Because the position of the shuttle 70 directly determines the amount of particulate media dispensed, overshoot and oscillation of the shuttle 70 would cause the particulate media to be dispensed unevenly, particularly when the valve 10 is first actuated or when the shuttle 70 is otherwise moved by the coil 32. Because of the eddy currents generated by the movement of the shuttle 70, overshoot and oscillation of the shuttle 70 are reduced or eliminated and the shuttle 70 responds in a damped fashion 75.

[0015] The valve 10 is separated into several general chambers where the particulate can be present or flow through, shown in FIGS. 5A and 5B. The valve 10 is designed to be attached in a vertical orientation, with axis 16 being aligned with the force of gravity and have a supply of media present in the inlet chamber 130. The inlet chamber 130 starts at the top edge 22 of the tube 20 and is generally comprised of the internal volume inside of the funnel 40 and shuttle sleeve 50. The outlet and sensor chamber 132 is defined by the internal volume starting at the sealing surface 94, extending between the outer diameter surface 102 and inner diameter surface 113 of the sensor body 112, and terminating at the arcuate apertures 106. The outlet and sensor chamber 132 will only contain particulate while it is flowing through the valve 10, while the inlet chamber 130 will contain media regardless of flow. Located between the inlet chamber 130 and outlet and sensor chamber 132 is a center chamber 134 that is defined by the internal volume between the terminal edge 56 and terminal sealing edge 80. The internal volumes herein described are the areas inside the valve 10 that can hold and dispense media. The internal volumes make up the flow path through the valve 10. The media contacts the inside surfaces 82, 84 of the shuttle sleeve 78. The center chamber 134, like the inlet chamber 130, may have media regardless of flow. Media that is released when the shuttle 70 moves and separates the terminal sealing edge 80 from the sealing surface 94 passes through the outlet and sensor chamber 132 substantially unimpeded. As the media passes through the portion of the outlet and sensor chamber 132 that is surrounded by the flow sensor 110, the media is detected by the flow sensor 110. Because the outlet and sensor chamber 132 is encircled by the sensor rings 114, 116

at an equal distance, the media is reliably detected. Detection is further enhanced by having the flow diverter 90 predictably locate the media in a flow path very near the sensor rings 114, 116.

[0016] It is understood that while certain aspects of the disclosed subject matter have been shown and described, the disclosed subject matter is not limited thereto and encompasses various other embodiments and aspects. No specific limitation with respect to the specific embodiments disclosed herein is intended or should be inferred. Modifications may be made to the disclosed subject matter as set forth in the following claims.

Claims

1. An electrically operated flow valve for particulate, said flow valve comprising:

an inlet portion having an inlet chamber, a repelling magnet fixed with respect to said inlet chamber, said inlet chamber extending from an inlet to a terminal edge on a shuttle sleeve;
 a sealing surface fixed with respect to said terminal edge on said shuttle sleeve;
 a shuttle circumscribing said shuttle sleeve and slidable with respect to said shuttle sleeve between an opened position and a closed position, said opened position defined by a sealing edge of said shuttle being spaced from said sealing surface and a shuttle magnet being closer to said repelling magnet, said closed position defined by said sealing edge of said shuttle contacting said sealing surface and a shuttle magnet being further from said repelling magnet, said inlet portion has a funnel shield located adjacent said repelling magnet and said shuttle having a shuttle magnet shield adjacent said shuttle magnet, said repelling magnet repelling said shuttle magnet to bias said shuttle towards said closed position;
 an outlet portion having an outlet chamber extending from said sealing surface to an outlet, a flow director fixed with respect to said shuttle sleeve for directing said particulate away from a central region of said outlet portion, said outlet portion including a capacitive sensor, said capacitive sensor located in a flow sensor body having a surface facing said fixed flow director, said surface cooperating with said fixed flow director to define an annular flow path; and
 a tube surrounding said shuttle magnet, said tube being fixed with respect to said shuttle sleeve and said tube being made from a material that generates eddy currents when said shuttle slides between said opened and closed positions.

2. The flow valve in claim 1, wherein said fixed flow director being cylindrical.
3. The flow valve in claim 1, said capacitive sensor having a first sensor ring adjacent a second sensor ring. 5
4. The flow valve in claim 1, said sealing surface on said fixed flow director being an annular groove.
5. The flow valve in claim 1, said fixed flow director having a cone portion, said cone portion located in a central chamber, said central chamber located between said inlet chamber and said outlet chamber. 10
6. The flow valve in claim 1, said inlet chamber has a funnel having a larger diameter near a top edge and narrowing to a smaller diameter towards said shuttle sleeve. 15

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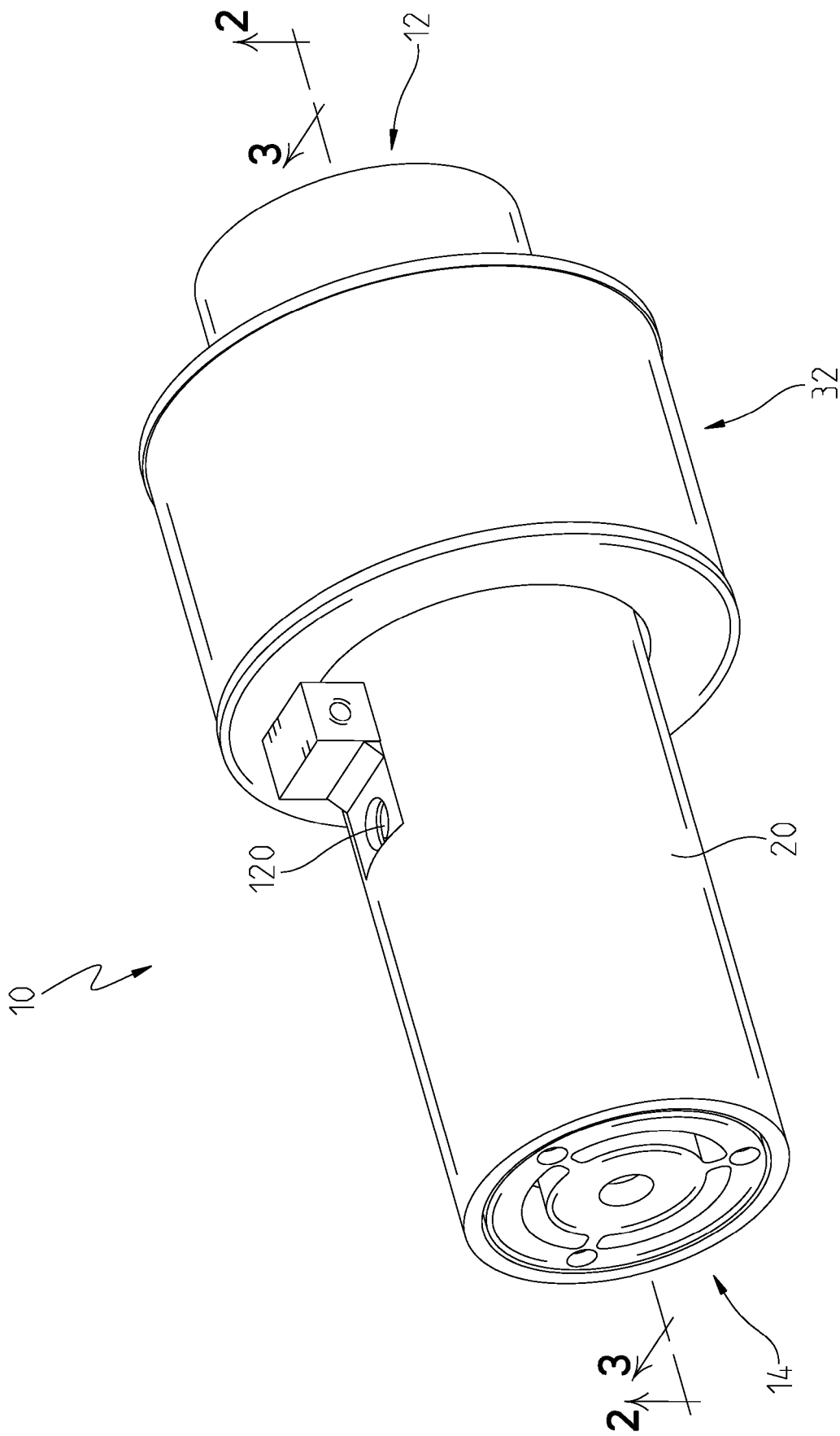


Fig. 1

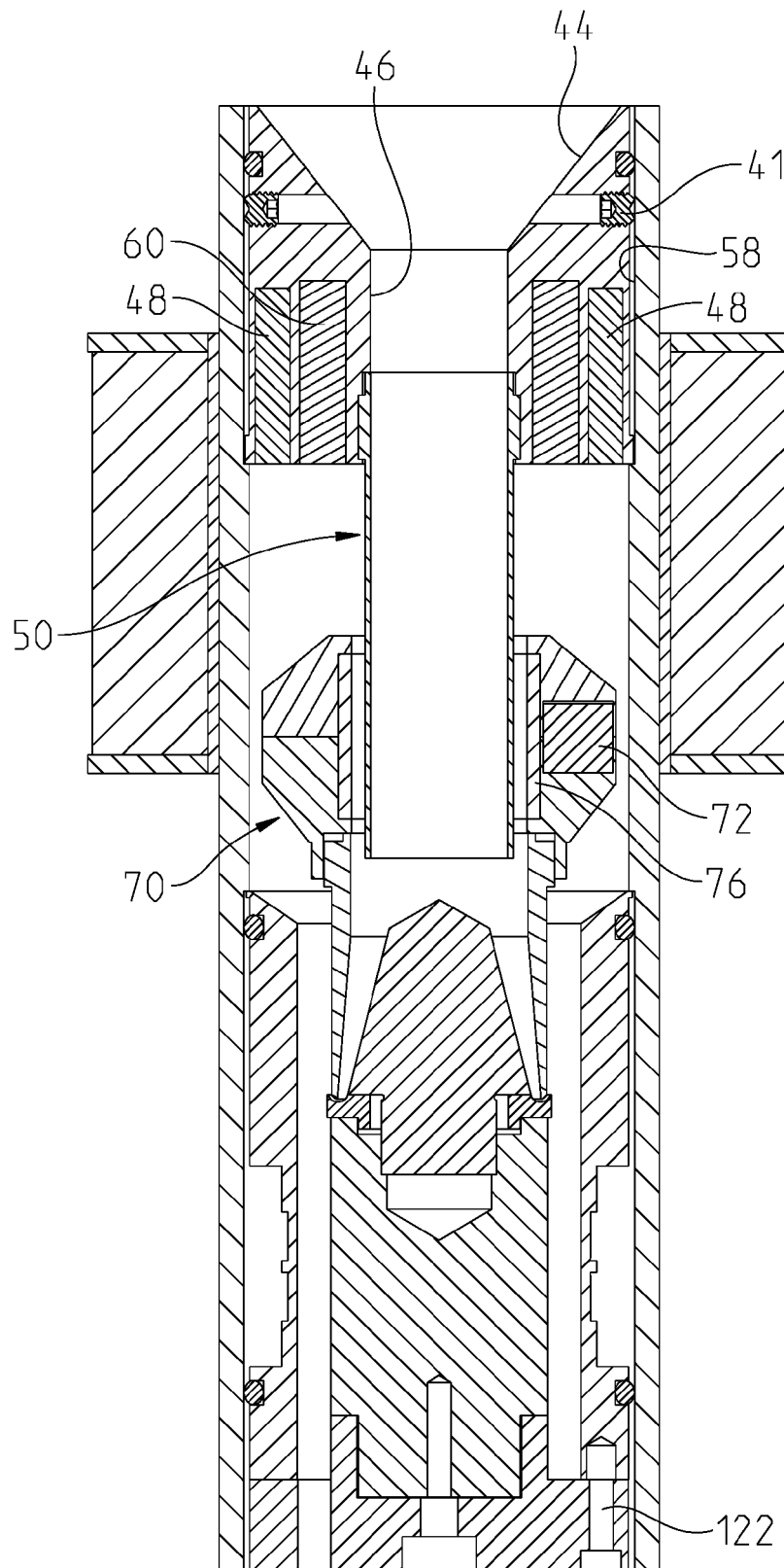


Fig. 2

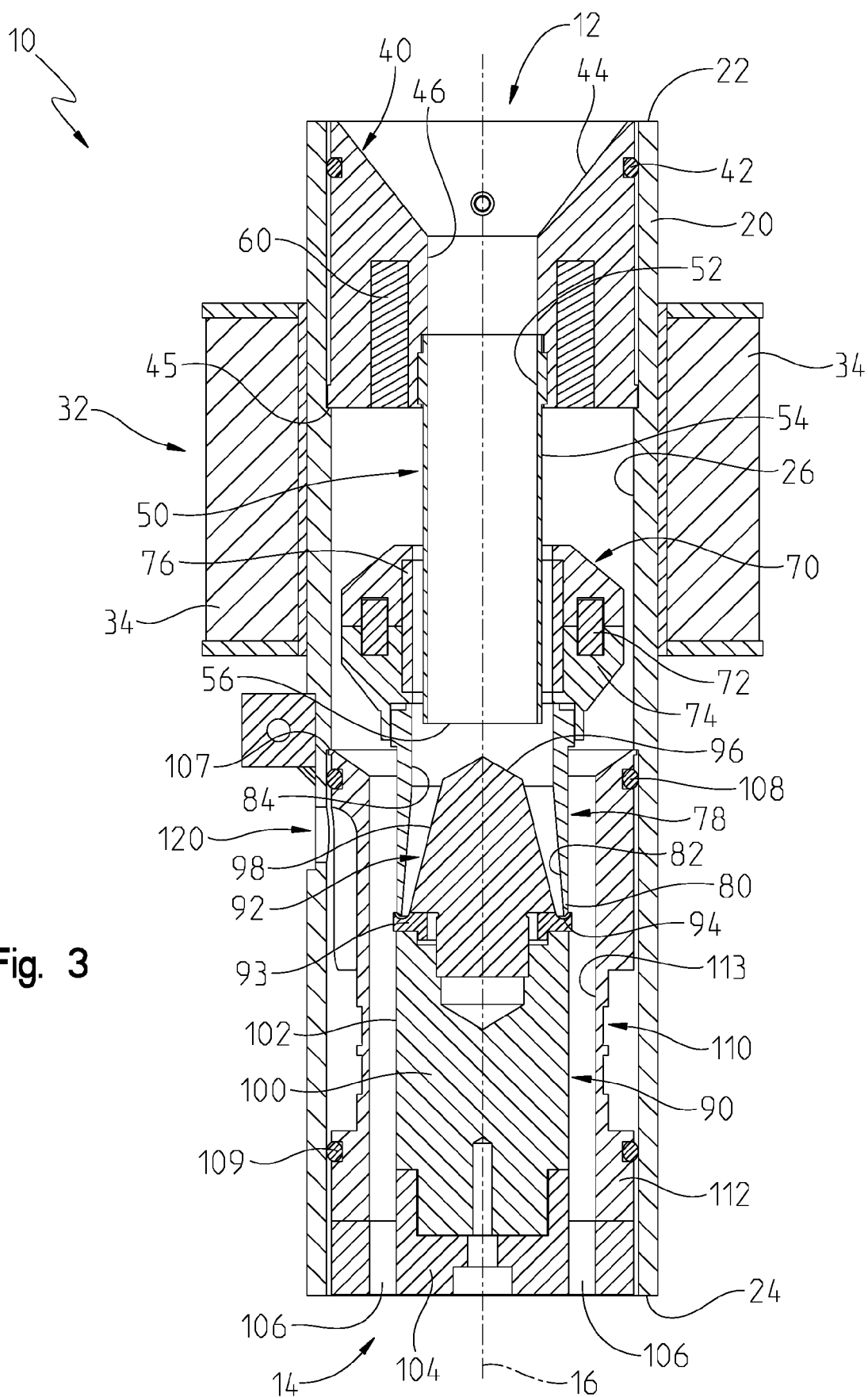


Fig. 3

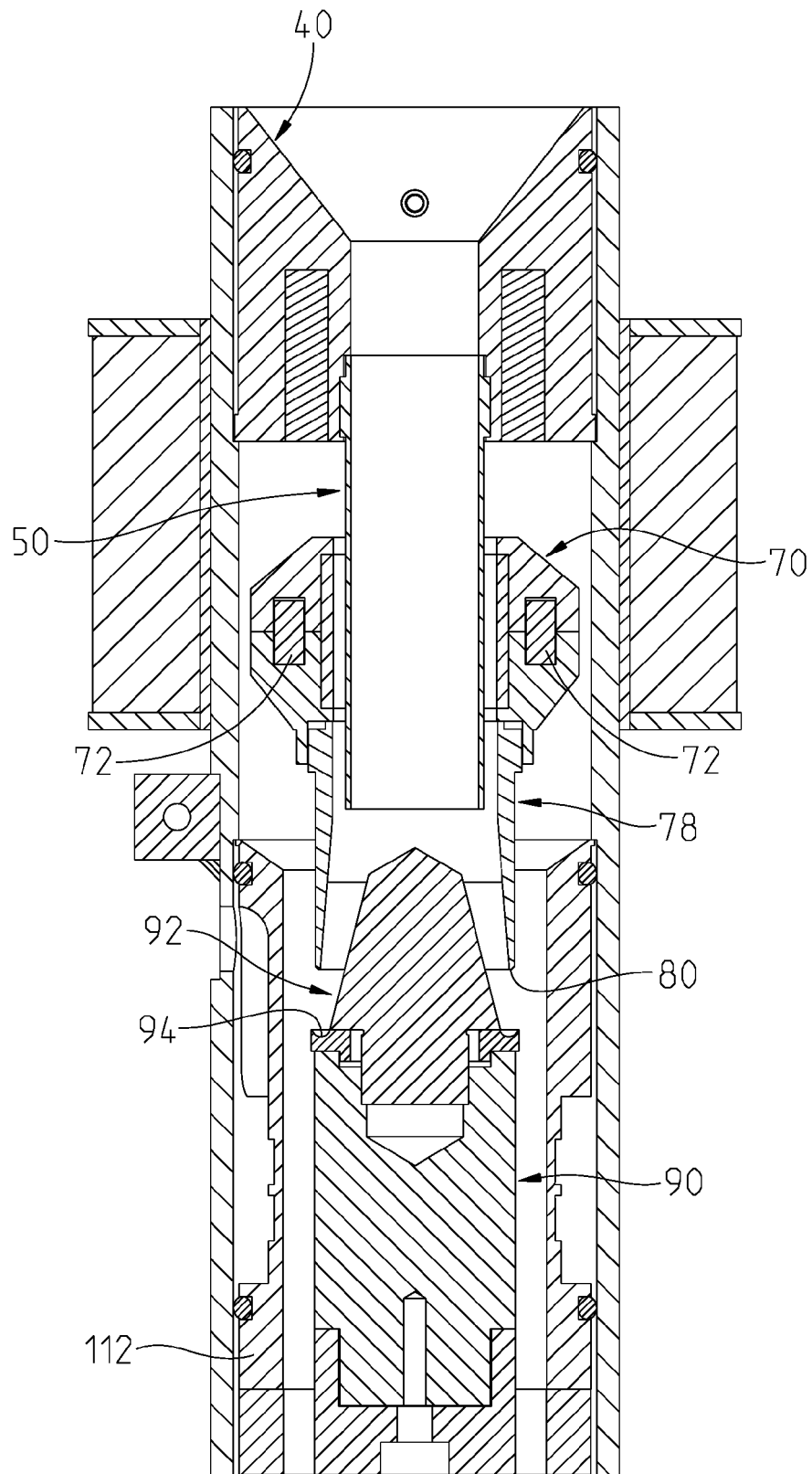


Fig. 4

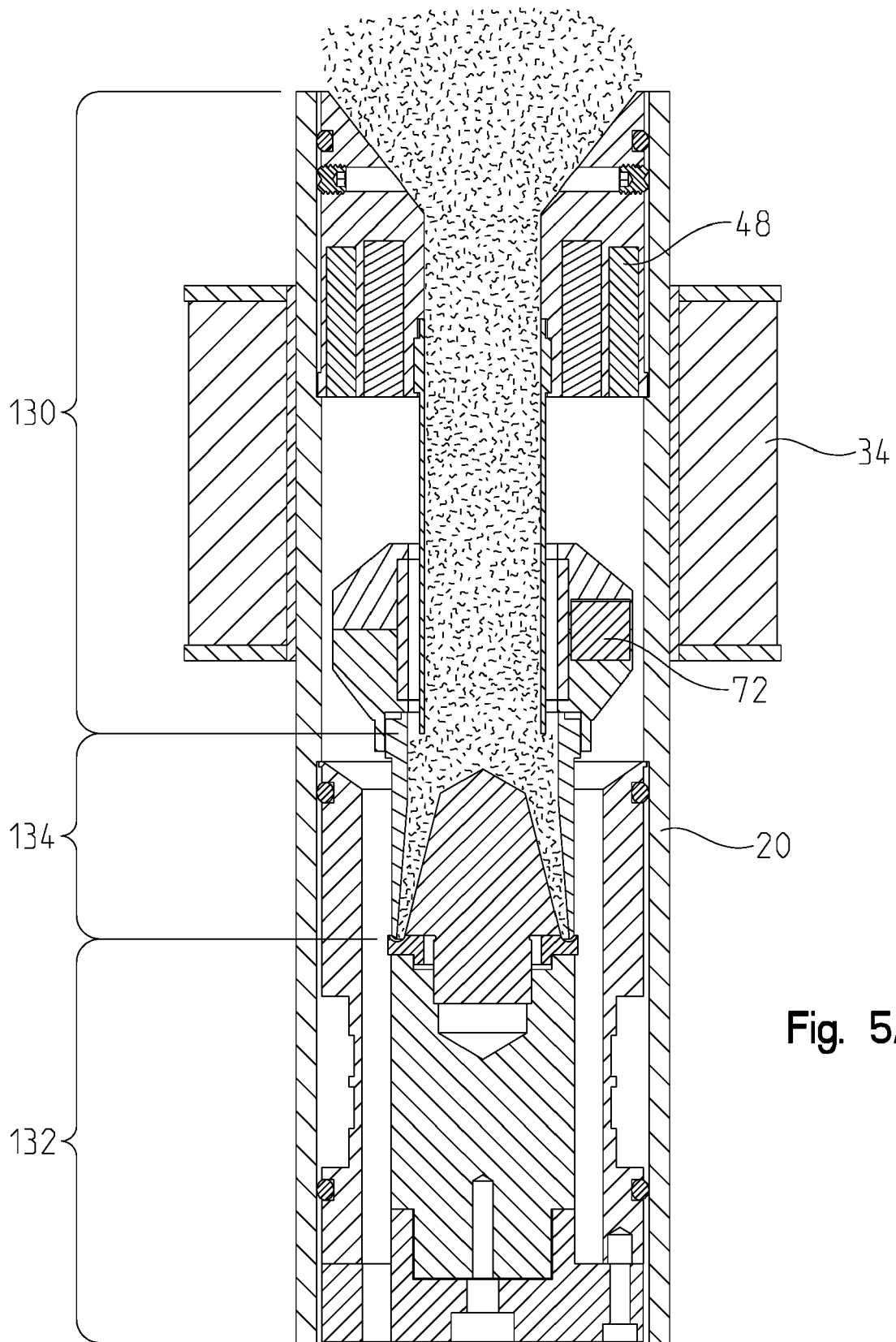


Fig. 5A

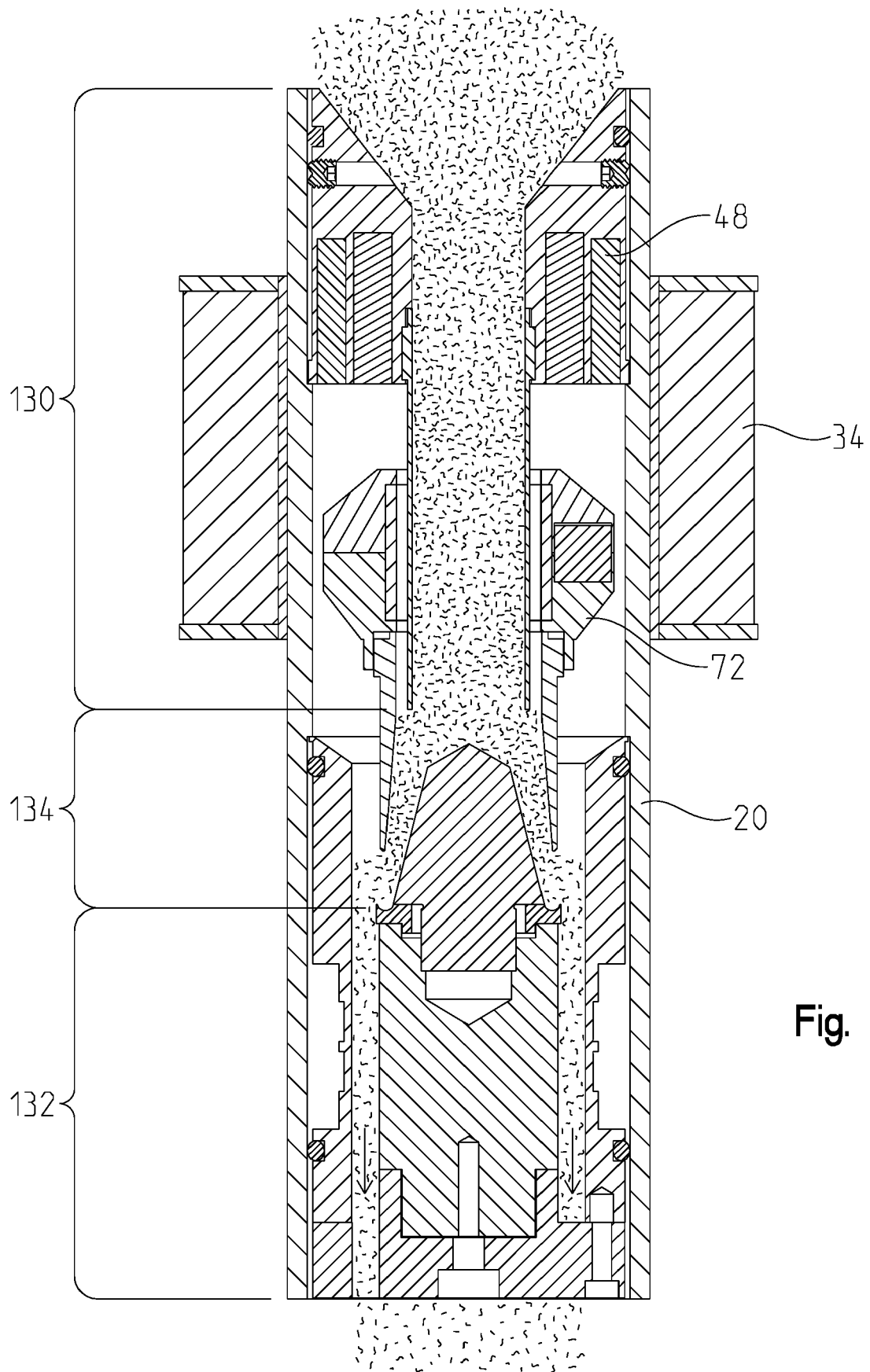


Fig. 5B

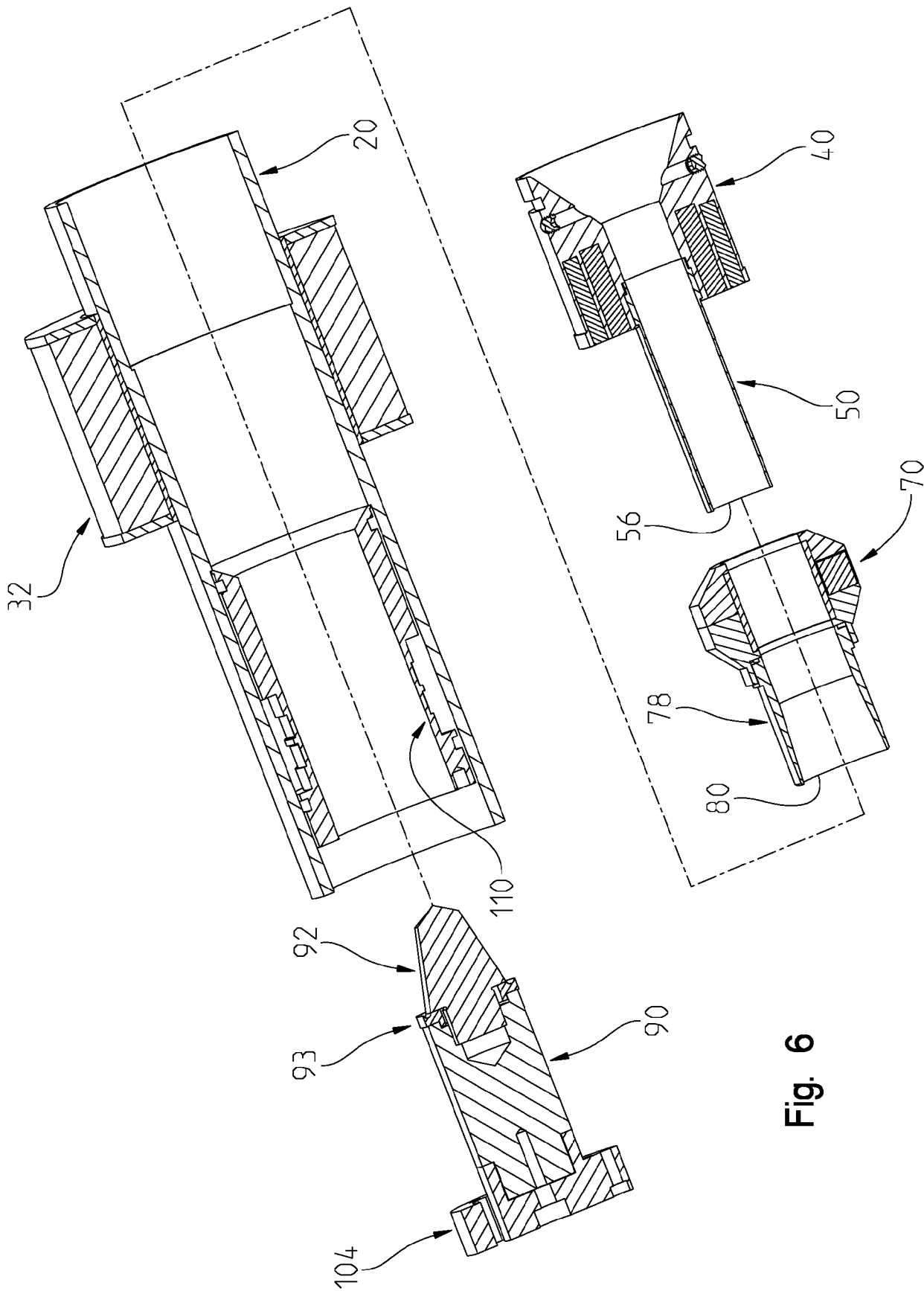


Fig. 6

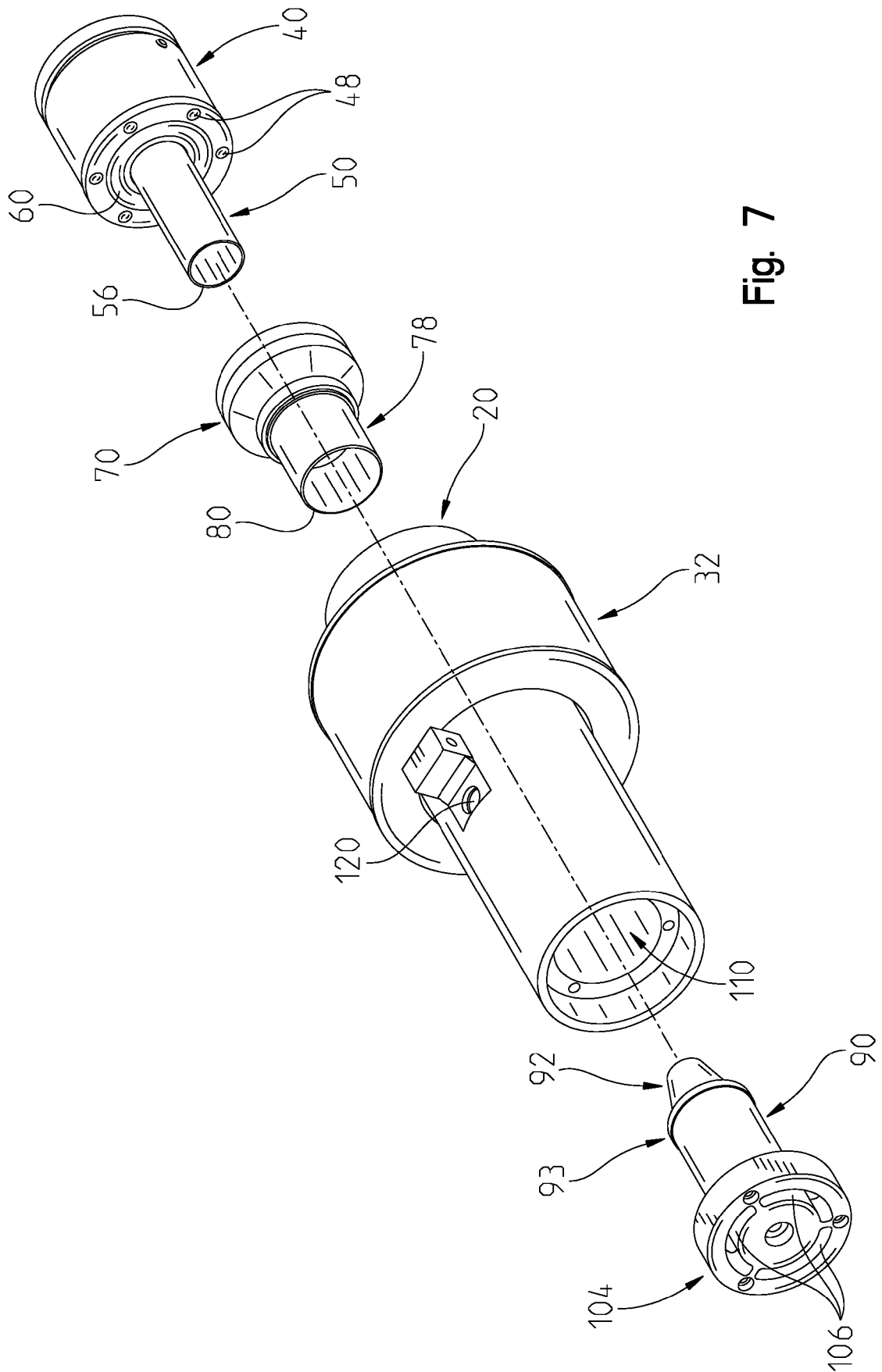


Fig. 7

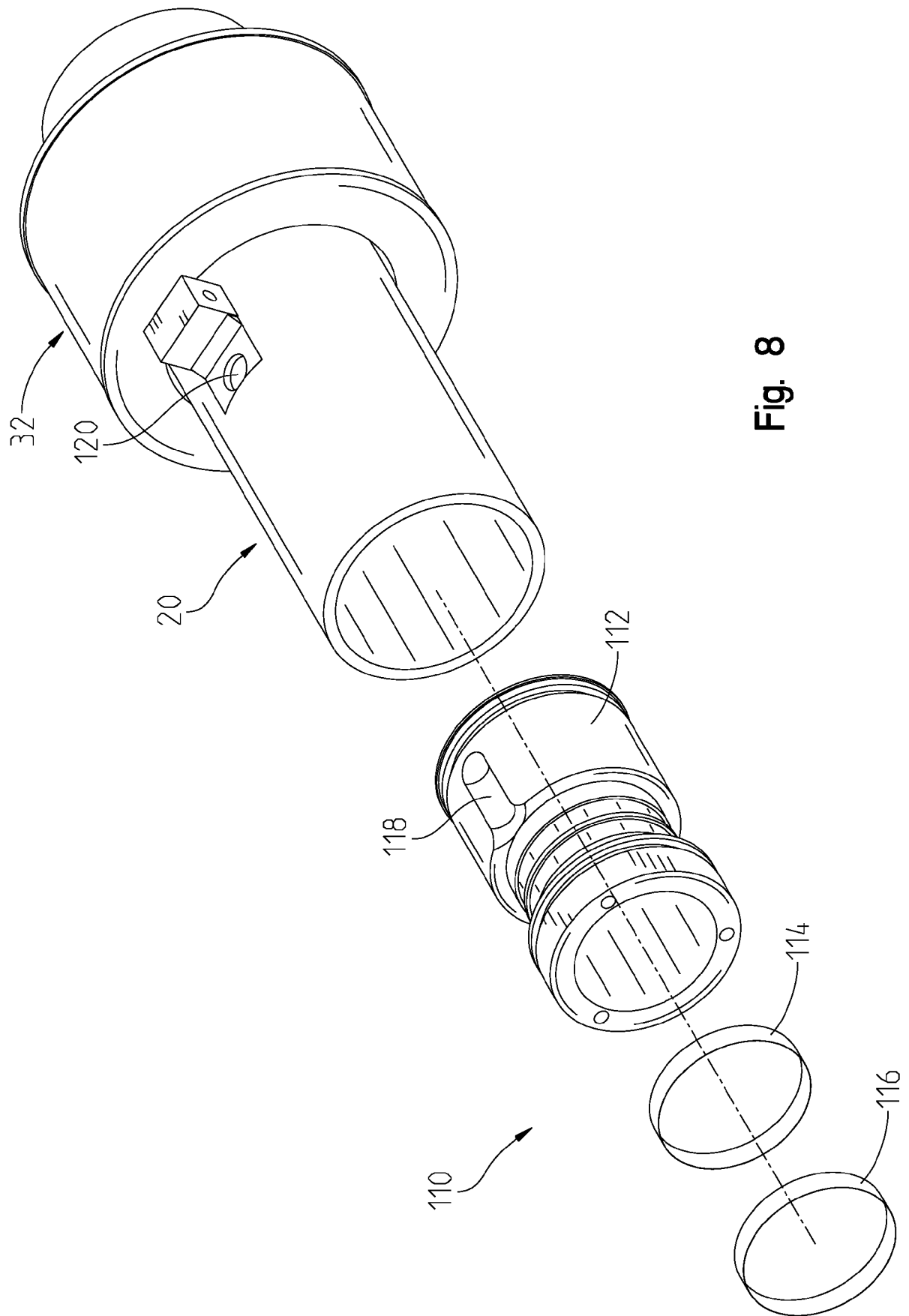
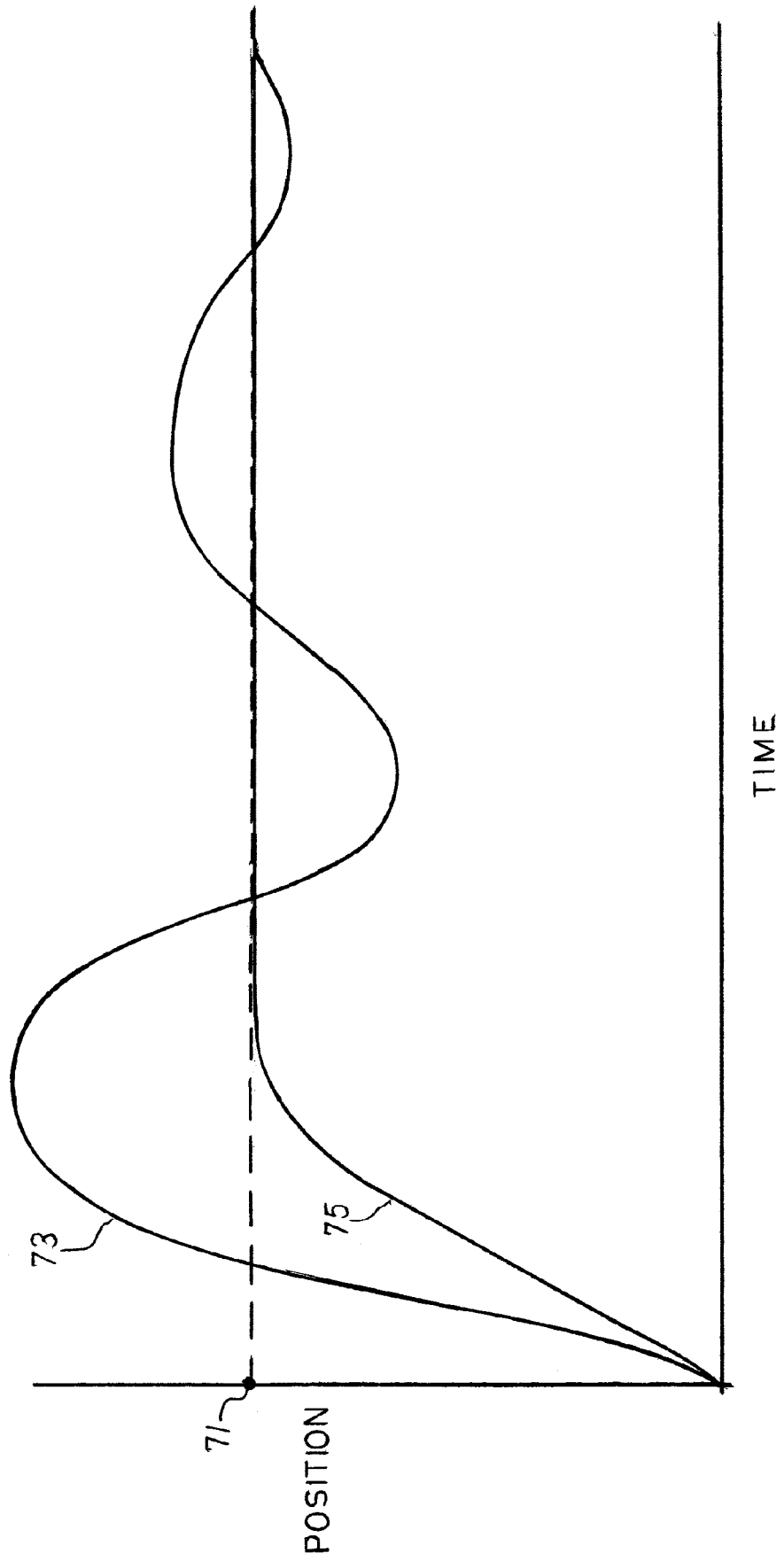


Fig. 8

FIG. 9





EUROPEAN SEARCH REPORT

Application Number
EP 19 17 1916

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
A	US 5 351 934 A (JENSEN RON B [US] ET AL) 4 October 1994 (1994-10-04) * column 2, line 11 - column 4, line 3; figures *	1	INV. F16K31/08 F16K31/06 F16K1/12 F16K37/00
A	US 2012/061596 A1 (HENSEL JOHN PETER [US] ET AL) 15 March 2012 (2012-03-15) * paragraph [0039] - paragraph [0067]; figures *	1	
			TECHNICAL FIELDS SEARCHED (IPC)
			F16K
The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 19 December 2019	Examiner Lanel, François
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.

EP 19 17 1916

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This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
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19-12-2019

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Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 5351934	A	04-10-1994	NONE

US 2012061596	A1	15-03-2012	NONE

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For more details about this annex : see Official Journal of the European Patent Office, No. 12/82